Work Order ID Thursday, August 18, 2		* (Page I
Item ID: D319: Revision ID: Item Name: Bracke Start Date: 8/18/2 Required Date: 8/25/2 Reference:	et Assembly 2011 Start Qty: 4,00		Accept	Cust Item ID: Customer:		Setup Start	1 (88%)
	ess Plan: Operation	Date:// O S-//	SPC (Y/N):	Date: Date: Tool ID Tool #	Plan Accep	Run Start	
Work Center ID	Description		Set Up/ Run Hours	10011D 1001#	Plan Accep Code Qty	t Reject Qty	Reject Insp. Number Stamp
Draw Nbr D3195	Revision Nbr Rev A						
00 Bandsaw caspa Bandsaw	BAND SAW Memo Cut blank	s: (1.250" x 1.500") x 3.60'	0.00	K, 11/08/22	8 8	-	3
110 HAAS 1 HAAS CNC vertical machin	HAAS CNC VERTIC Memo e #1 1-Machin 3 12-Deb	e D <u>3195-</u> 3 as per Folio FA	0.00 0.00 334 and Dwg D3195 Identi	or 1 / F.K.	11/08/23	J.	
20 QC Quality Control	QC2- Inspect parts off Memo	machine FAI/FAIB	0.00 orl	F.L. 11/08/22	8		

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Dart Aerospace L	.td
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. —									
W/O:			V	WORK ORDER CHANG	ES				•
DATE	STEP	PROC	CEDURE CI	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·		۶	
		•							
		·							
Part No	:	PAR #:	_ Fault Ca	ategory:	NCR: Ye	s No DQ	A:	_ Date: _	1
		esolution:							
NCR:		, W	ORK OR	DER NON-CONFORMA	ANCE (NO	CR)			
DATE	STEP	Description of NC -	Corrective Action Section			Verifi	cation		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		ion C	Chief Eng	QC Inspector
		-							
			-						
				7					
		·						-	
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								٠.	·

Work Order ID 72925

Thursday, August 18, 2011 10:08:19 AM

Item ID:

D3195-043

Accept

Setup Start



Revision ID:

Item Name:

Bracket Assembly

Start Date: 8/18/2011

Start Qty: 4.00 Req'd Qty: 4.00

Cust Item ID:

Customer:

Tool ID

Reference:

QC:

Required Date: 8/25/2011

Tooling:

0.00

0.00

Date:

Start

Stop

Approvals:

Process Plan:

Date:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Operation **Description**

QC8- Inspect parts - second check

Memo

Memo

Memo

Set Up/ **Run Hours**

B.A 11/08/23

Tool # Plan Code

Accept Qty

Reject **Qty**

Run

Reject Insp. Number

Stamp

Quality Control

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

0.00

8x 6 m-f 11/08/24

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

START TIME:

8x 8 m- Lulo8/24

W/O:	·		W	ORK ORDER CHANG	ES				
DATE	STEP	PROC	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·
Part No		PAR #:	_ Fault Cat	egory:	NCR: Yes	No DQA	\ :	Date:	
	Re	esolution:	_ Disposit	on:	_ QA: N/C Cld	sed:		Date: _	
NCR:		W	ORK ORI	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description	on B Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
		•	Cinel Eng	Chief Eng	Date				
		_			·		_		

Work Order ID 72925

Thursday, August 18, 2011 10:08:19 AM



Page 3

Item ID:

D3195-043

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 8/25/2011

Bracket Assembly

8/18/2011

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item 1D:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Date: SPC(Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Part Office

Tool # Plan

Accept** Qty Code

Reject Oty

Reject Number

Insp. Stamp

BK 11-8-24

1/08/05

170

Small Fab Small Fab

Small Fab

Memo

0.00

0.00

1-Lightly Sand bonding surface 12-Bond D3195-7 into D3195-13as per Dwg

D3195[]A/RContact Cement M 11090

QC5- Inspect part completeness to step on W/O

0.00

180

Quality Control

Memo

0 wos 125

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	CEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			·											
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _					
		esolution:				: N/C Cld	osed:		Date: _					
NCR:			WORK OR	DER NON-CONFOR	RMANCE	(NCR)			***				
DATE	STEP	Description of NC			Section B	0: 0	Verific	cation	Approval	Approval				
	J.L.	Section A	Initial Chief Eng	Action Descripti Chief Eng	on ———	Sign & Date	Secti	ion C	Chief Eng	QC Inspector				
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		-												
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1														

Work Order ID 72925

Thursday, August 18, 2011 10:08:19 AM



Page 4

Item ID:

D3195-043

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 8/25/2011

Bracket Assembly

Start Date: 8/18/2011 Start Qty: 4.00

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Òty

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/

Work Center ID

190

Packaging

Operation Description

Identify as per dwg & Stock Location. \$\sim 246 \text{ } 0.00

Memo

Memo

Run Hours

0.00

ToolAD

Tool # Plan Code Accept Qty

Reject Reject Number

Stamp

Packaging

200

0.00

Quality Control

QC21- Final Inspection - Work Order Release

0.00

4668.9

W/O:			V	ORK ORDER CHA	ANGES					
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
							-			
						<u> </u>			· · · · · · · · · · · · · · · · · · ·	
Part No	·	PAR #:	_ Fault Ca	tegory:	NC	R: Yes	No DQA	.:	_ Date: _	
	R	esolution:							Date:	
NCR:		W	ORK OR	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC	In IAI at	Corrective Action	Section B	Sign &	Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Descrip Chief Eng	uon ———	Date	Section	n C	Chief Eng	QC Inspector
			•							
			-							
		·		1						
			-						-	
•						•				
			•							

Picklist Print

Thursday, August 18, 2011 10:08:25 AM

Work Order ID: 72925

Parent Item:

D3195-043

Parent Item Name: Bracket Assembly



• 110936 № 118071

118400

Start Date: 8/18/2011

Required Date: 8/25/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

	Comments: IF	PRev:A New I	ssue 05-11-08	JLM										
-	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
4	Dad		Manufactured	No			100	Each	4.0000		3/3/1/	108/2	5	
	1 au				<u>Location</u> GA		Loc	<u>Qtv</u> 4	Loc Code			6	7304	10(4x)
	M6061T6B1.500X01.25		Purchased	No		69385	170	f	21.4298	0.3	1.263158			
	6061-T6 Bar 1.50 x 1.25									1	K,	11/6	78/-	22.
	•				Location MAT004		<u>Loc (</u> 21.	<u>Oty</u> 1298	Loc Code					

2.5428

6.887 - 12

W/O:			V	ORK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		The Prince of th							
			:						
Part No		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _	, , , , , , , , , , , , , , , , , , ,
	R	esolution:	Disposit	ion:	QA: N/C C	osed:		Date: _	
NCR:	-		WORK OR	DER NON-CONFORMA	NCE (NCF	₹)	· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	Description of NC		Corrective Action Section B			Verification /		Approval
DAIL	31LF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
			. क						
									-
			,			+			
				,					

DART AEROSPACE LTD	Work Order:	72924
Description: Bracket	Part Number:	D3195-3
Description. Dracket	Part Number.	D3 195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1

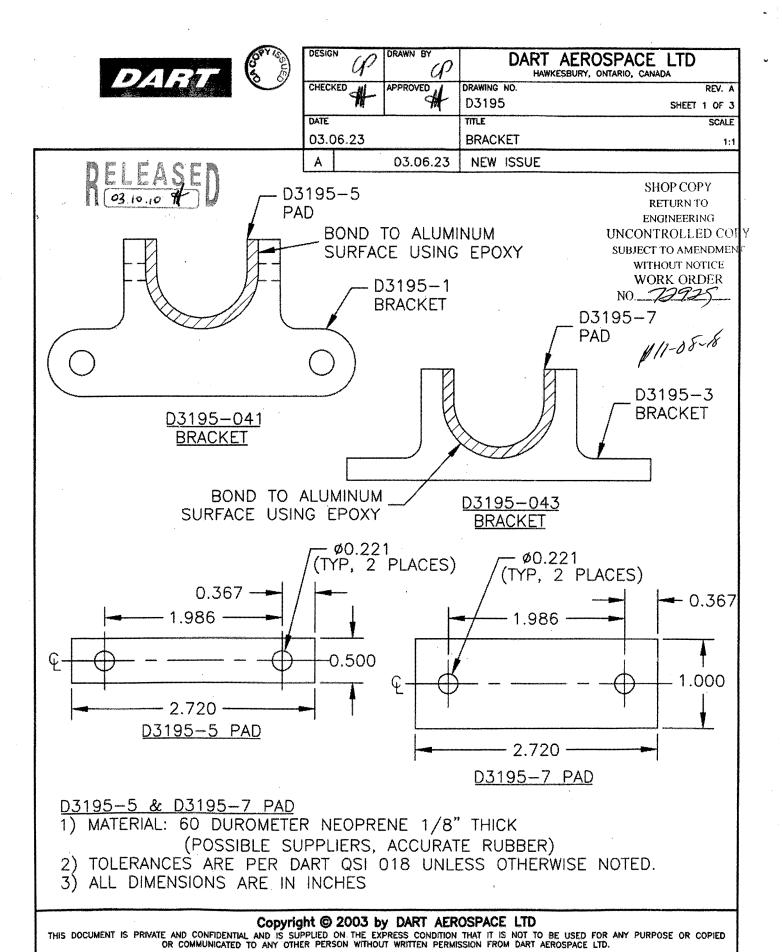
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Proto	type
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Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
3.432	+/-0.010	3-431			-	
1.265	+/-0.010	1,264	-			
R0.37	+/-0.030	R-37			:	
Ø0.277	+0.005/-0.000	852,4				
2.677		2.677				
0.242	+/-0.010	.242		,		
0.377	+/-0.010	.375				
0.500	+/-0.010	. 499				
R0.188	+/-0.010	R.188				
0.250	+/-0.010	.247				
0.882	+/-0.010	.885				
1.250	+/-0.010	1.248				
0.500	+/-0.010	.502				
Ø0.191	+0.005/-0.000	\$0191				
1.000	+/-0.010	1.000				
					- "	۲
					' :	
				-1		

Measured by: The low	Audited by:	A.C.	Prototype Approval:	N/A
Date: ///08/22	Date:	11/08/23	Date:	N/A

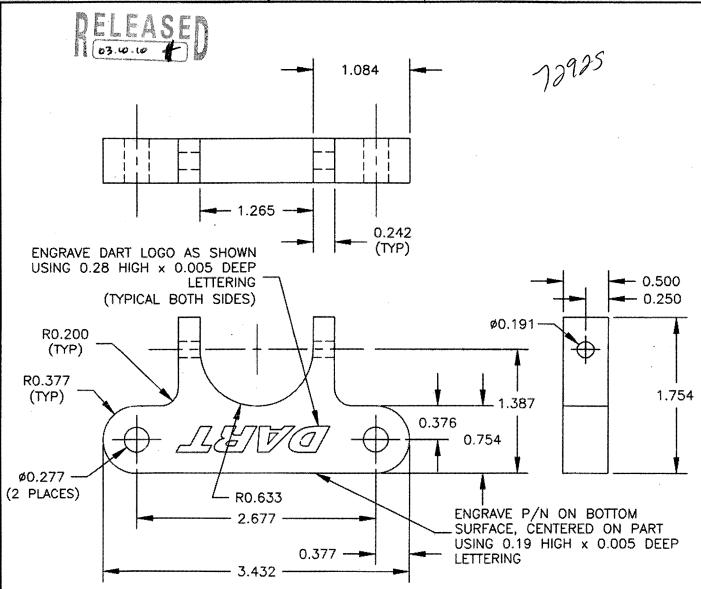
Rev	Date	Change	·	Revised by	Approved
Α	04.04.20	New Issue	(P/O D412-702-011/-013)	KJ/RF 1.4	-1
В	05.04.26	R0.37 was R0.0	037; 1.084 removed	KJ/JLM C	- (11)







DESIGN	4	DRAWN BY	DA	RT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKE	D	APPROVED	DRAWING NO.		REV.	Α
	M	#	D3195	SHEET	2 OF	3
DATE			TITLE		SCA	VLE
03.06	3.23		BRACKET			1:1



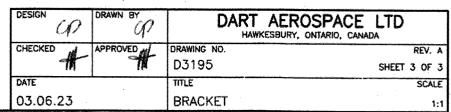
D3195-1 BRACKET

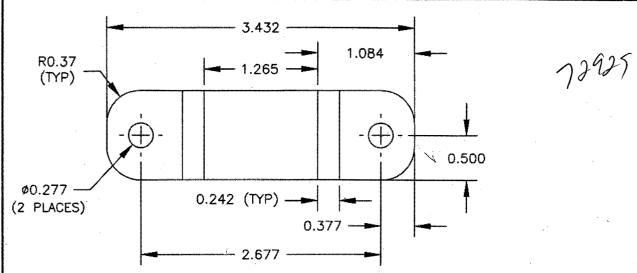
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

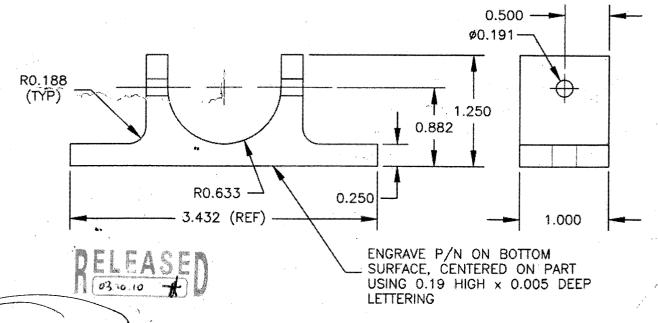
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D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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